

Date: Wednesday, 18/07/2007 7:17:39 AM
User: Linda Lacelle

Process Sheet

| | | | |
|-----------------------|---------------------------------------|------------------|-------------------------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : STRUT WELDMENT ASS'Y |
| Job Number | : 33616 | | |
| Estimate Number | : 10566 | | |
| P.O. Number | : <i>N/A</i> | Part Number | : D34435 |
| This Issue | : 18/07/2007 S.O. No. : <i>N/A</i> | Drawing Number | : D3443 REV.B |
| Prsht Rev. | : NO | Project Number | : N/A |
| First Issue | : <i>N/A</i> Type : SMALL /MED FAB | Drawing Revision | : B |
| Previous Run | : 29840 | Material | : <i>N/A</i> |
| Written By | : <i>[Signature]</i> | Due Date | : 25/07/2007 Qty: 10 Um: Each |
| Checked & Approved By | : <i>[Signature]</i> | | |
| Comment | : A 05.11.14 New issue EC | | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|-----|----------------|-----------|
| 1.0 | M304TR0750W120 | Inventory |
|-----|----------------|-----------|



Comment: Qty.: 0.5198 f(s)/Unit Total : 5.1975 f(s)

Inventory

AISI 304 SS seamless tubing .750 OD x 0.120 wall

(M304TR0750W120)

Batch: *M103240*

FF 07-07-18 10

| | | |
|-----|----------|----------|
| 2.0 | BAND SAW | BAND SAW |
|-----|----------|----------|



Comment: BAND SAW

1-Cut blank 5.97 " long

2-Deburr

FF 07-07-18 10

| | | |
|-----|---------------|------------------------------|
| 3.0 | MILLING CONV. | CONVENTIONAL MILLING MACHINE |
|-----|---------------|------------------------------|



Comment: CONVENTIONAL MILLING MACHINE

1- Mill to length and drill holes as per dwg D3443

2-Deburr as per dwg D3443

FF 07-07-20 10

| | | |
|-----|-----|--|
| 4.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

FF 07-07-20 10

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 01/07/23
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Wednesday, 18/07/2007 7:17:39 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT WELDMENT ASS'Y

Job Number: 33616

Part Number: D34435

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.F. 07/07/20 (19)

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____

7/760 (10X) 50

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(18)
07/07/20

Job Completion



U 07-07-23

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

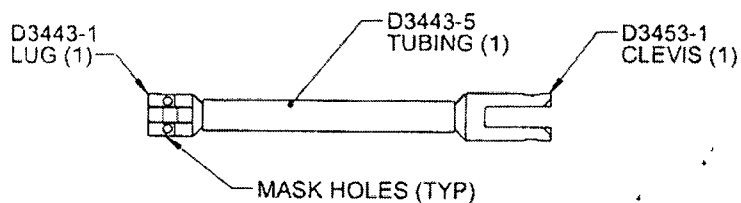
NOTE: Date & initial all entries



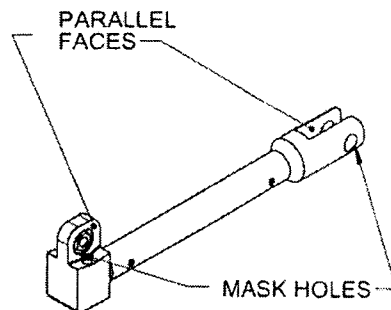
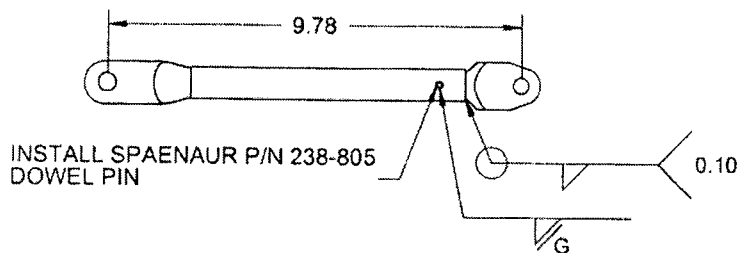
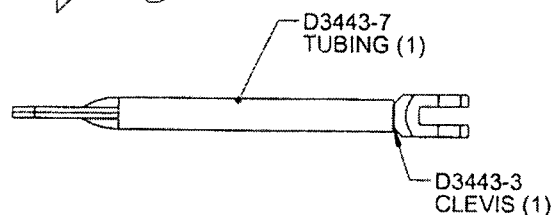
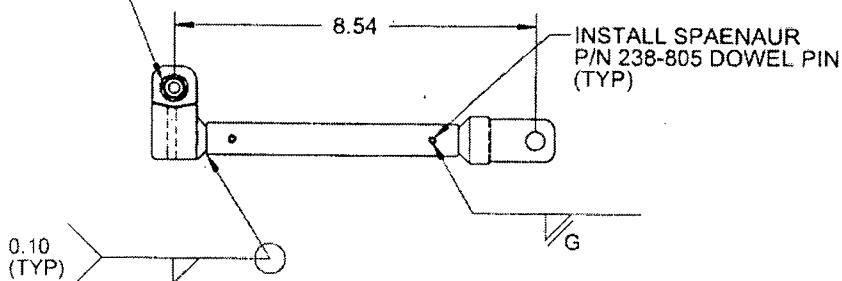
| | | | |
|----------------------------|-----------------------------|---|------------------------|
| DESIGN RF | DRAWN BY RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3443 | REV. B SHEET 1 OF 3 |
| DATE 05.12.05 | | TITLE STRUT WELDMENT ASSEMBLY | SCALE 1:4 |
| A | 05.09.02 | NEW ISSUE | |
| B | 05.12.05 | ADDED -9 PIN; REMOVED BALL PLUNGER; REVISE TOLERANCE; & Ø0.125 WAS #30 | |

RELEASED

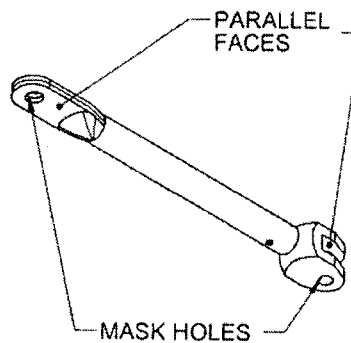
05.12.09 *[Signature]*



PRESS FIT McMASTER-CARR P/N 63215K32
BALL JOINT BEARING AFTER POWDER COAT



D3443-041



D3443-043

NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

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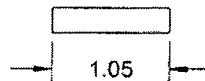
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W1033616



| | | | |
|------------------------|--|---|------------------------|
| DESIGN RF | DRAWN BY RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED [Signature] | APPROVED [Signature] | DRAWING NO. D3443 | REV. B SHEET 3 OF 3 |
| DATE 05.12.05 | TITLE STRUT WELDMENT ASSEMBLY SCALE 1:2 | | |

$\phi 0.210^{+0.005}_{-0.010}$



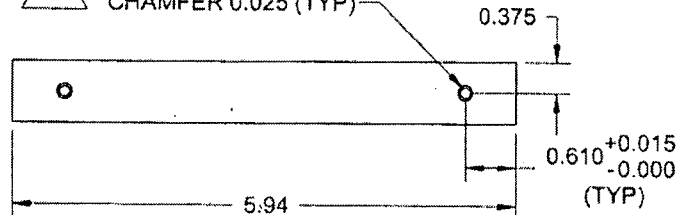
D3443-9 PIN

D3443-9 NOTES:

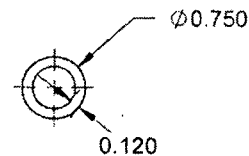
- 1) MATERIAL: DELRIN II 150R OR ACETRON GP ACETAIL (REF. DART SPEC M-DELRIN-R)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES



DRILL $\phi 0.125$ THRU
CHAMFER 0.025 (TYP)

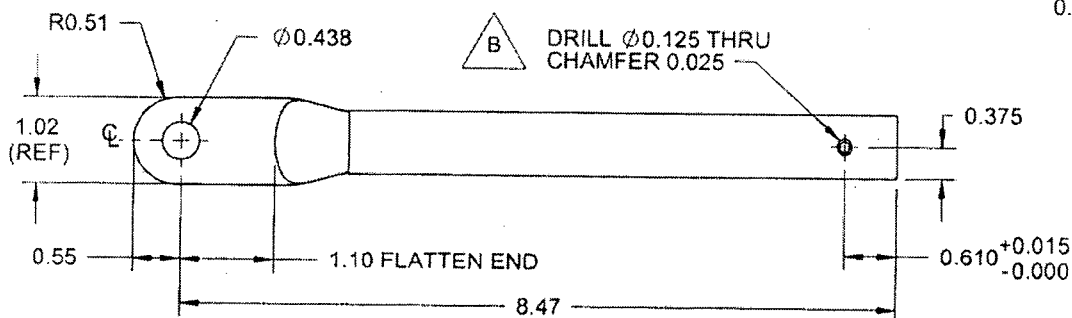
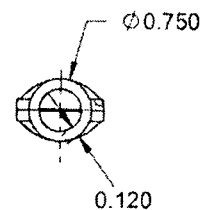
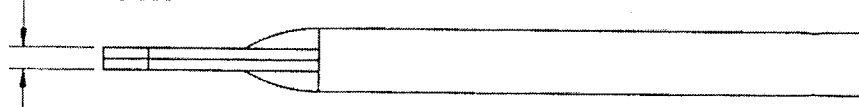


RELEASED
05.12.09 [Signature]



D3443-5 TUBING

$0.260^{+0.000}_{-0.030}$



D3443-7 TUBING

D3443-5/-7 NOTES:

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC M304TR0.7500W.120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.025

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| | | |
|--|---------------------|-------------|
| DART AEROSPACE LTD | Work Order: | 33616 |
| Description: Trailing | Part Number: | 03443-5 |
| Inspection Dwg: 03443 Rev: B | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

| | | | |
|-------------------------------------|---------------|--------------------------|-----------|
| <input checked="" type="checkbox"/> | First Article | <input type="checkbox"/> | Prototype |
|-------------------------------------|---------------|--------------------------|-----------|

[illegible]

| | | |
|------------------------|-------------------------|---------------------|
| Measured by: <u>36</u> | Audited by: <u>J.F.</u> | Prototype Approval: |
| Date: <u>07-07-20</u> | Date: <u>07/07/20</u> | Date: |

| Rev | Date | Change | Revised by | Approved |
|-----|------|-----------|------------|----------|
| A | | New Issue | KJ/JLM | |